

ABSTRACT OF THE DISCLOSURE

5 A green tire (24) prepared by superposing an inner
liner (2) onto the inner surface of a tire body (1) is
set in an upper die (29) and a lower die (30). In this
condition, a pressure bag (31) placed inside the green
tire (24) is expanded by air pressure to perform
vulcanization and forming. At this time, a mold release
sheet (9) such as a fluoro resin sheet having a mold
10 releasing property on one surface only is interposed
between a part of the inner liner (2) and the tire body
(1) in such a manner that the surface having the mold
releasing property is opposed to the inner liner (2).
Accordingly, the inner liner (2) is prevented from being
15 bonded by vulcanization to the tire body (1), thereby
forming a sealant chamber having a proper shape for
charging a sealant thereto. In case the mold release
sheet (9) is formed of a material soluble in the sealant,
a reduction in sealability of the sealant due to the mold
20 release sheet (9) left in the sealant chamber can be
avoided.

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